

Work Order ID 65530

Wednesday, January 19, 2011 1:02:05 PM



SHIP 26 latest

Page 1

Item ID: DSI 9464-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Tuning

Start Date: 1/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-01-19 Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3955	A
-------	---

DSI 9464	B
----------	---

0.00

0.00

100



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

Sub 124

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/12/11 SPD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65530

Wednesday, January 19, 2011 1:02:06 PM



Page 2

Item ID: DSI 9464-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Tuning

Start Date: 1/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S Monty



Memo

0.00

130



Packaging

Packaging

Memo

Identify and pack for shipping as per PPP DSI 9464-011

Location: 30

PPP rev: A

0.00

0.00

11/24sf

10

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

OK 11/01/24

*mf
11-01-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 19, 2011 1:02:02 PM

Page 1

Work Order ID: 65530

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 1/20/2011

Required Date: 1/26/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-553 DD 10.04.19 verified byEC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3955-041 Doubler Assembly		Manufactured	No			110	Each	0.0000	2	2		11/1/24	
D3955-3 Cover Plate		Manufactured	No			110	Each	1.0000	2	2		11/1/24	

Location	Loc Qty	Loc Code
----------	---------	----------

ST102

1

60517

1

D3955-5 Plate		Manufactured	No			110	Each	0.0000	2	2		11/1/24	
D3955-7 Plate		Manufactured	No			110	Each	1.0000	6	6		11/1/24	

Location	Loc Qty	Loc Code
----------	---------	----------

ST103

1

61797

1

D3955-21 Gasket		Manufactured	No			110	Each	2.0000	2	2		11/1/24	
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	---------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST103

2

60518

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 65530

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 1/20/2011

Required Date: 1/26/2011

Start Qty: 1.00

Required Qty: 1.00

D3955-23

Manufactured No

110

Each

1.0000

-2

12

(A)

B65548

11/1/2011

Template

Location

Loc Qty

Loc Code

ST105

1

59318

1

CR3212-4-04

Purchased

No

110

Each

825.0000

38

38

Cherry Rivet

Location

Loc Qty

Loc Code

ST311

825

112314

25

113749

200

115698

200

116471

400

AN3-5A

Purchased

No

110

Each

1,085.000

4

4

Bolt

Location

Loc Qty

Loc Code

ST350

1085

115016

385

115371

500

116632

200

AN3-6A

Purchased

No

110

Each

176.0000

4

4

Bolt

Location

Loc Qty

Loc Code

ST351

176

114941

126

116191

50

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 19, 2011 1:02:02 PM

Page 3

Work Order ID: 65530

Parent Item: DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 1/20/2011

Required Date: 1/26/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-7A

Purchased

No

110

Each

70.0000

4



Bolt

Location

Loc Qty

Loc Code

ST351

70

113539

14

114227

4

114784

52



4
11/10/11

AN3-10A

Purchased

No

110

Each

127.0000

4



Bolt

Location

Loc Qty

Loc Code

ST351

127

115877

1

116075

26

116400

100



4
11/10/11

NAS1149D0332J

Purchased

No

110

Each

411.0000

6



Washer

Location

Loc Qty

Loc Code

ST298

411

116441

411



6
11/10/11

MS21042L3

Purchased

No

110

Each

3,195.000

2



Nut

Location

Loc Qty

Loc Code

ST300

3195

114784

9

115835

686

116391

900

116540

800

116549

800



2
11/10/11

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

8

DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skidtube in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skidtube.

Procedure:

Note: Installer must be careful not to damage underlying skidtube during drilling operations.

- 1) Locate D3955-23 template on the fwd cap of the skidtube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skidtube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skidtube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skidtube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skidtube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:






The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9464	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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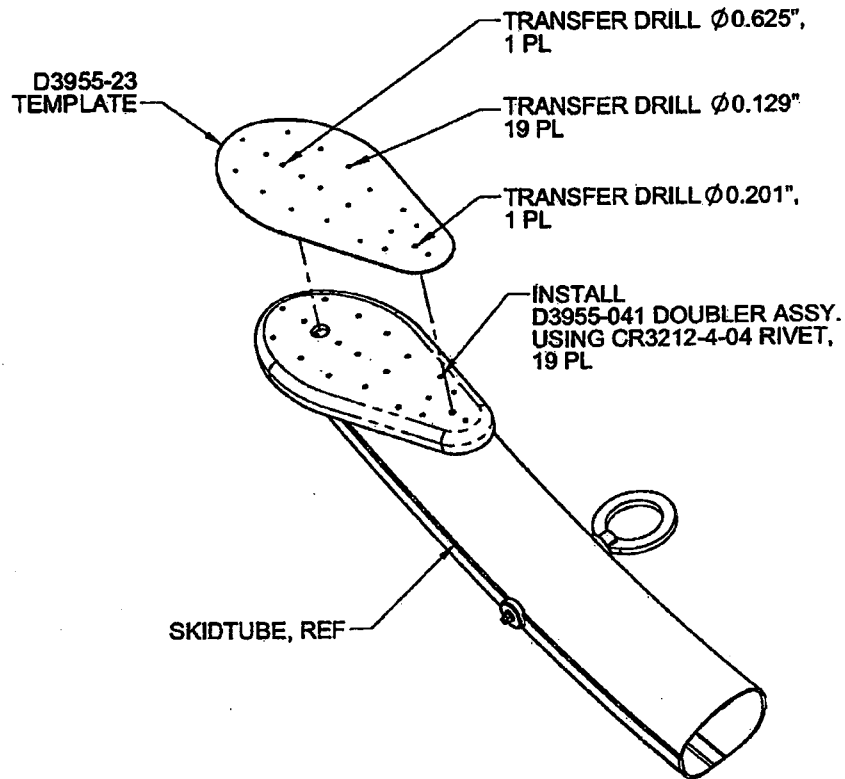


Figure 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

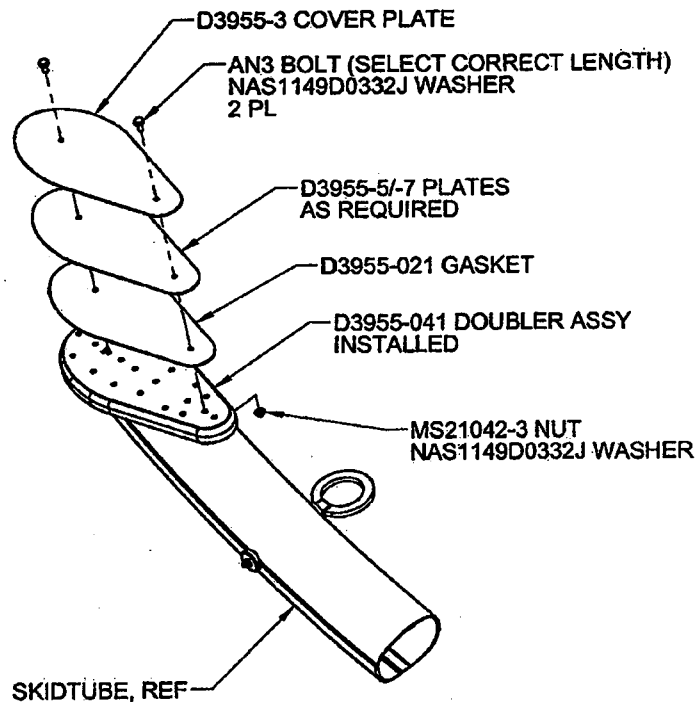


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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